

Date: Tuesday, 15/07/2008 9:15:39 AM
 User: Julie Lecocq

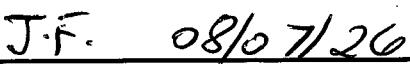
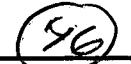
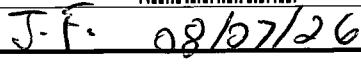
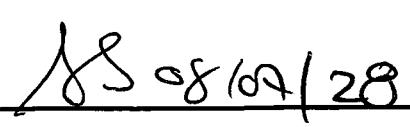
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BEARING ASSEMBLY		
Job Number	: 40496					
Estimate Number	: 11136					
P.O. Number	:			Part Number	: D3183045	
This Issue	: 15/07/2008		S.O. No. :	Drawing Number	: D3183 REV C1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: C1	
Previous Run	: 40159			Material	:	
Written By	:			Due Date	: 30/07/2008	
Checked & Approved By	: JUL 08.15.08			Qty:	40 Um: Each	
Comment	: Est A04.02.18 New issue KJ/DS					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR1000	Delrin Round Bar 1"	
		Comment: Qty.: 0.0350 f(s)/Unit Total : 1.3986 f(s) Delrin Round Bar 1" Material: 01.00-Delrin Rod 81.250 DELRIN ROD (M-DELRIN-R1.000) Identify as D3183-9 Batch: M107758	J.F. 08/07/26  
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn D3183-9 Cap as per Folio FA388 Deburr	J.F. 08/07/26  
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 08/07/26  
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	20 08/07/26 
5.0	D31835	Bearing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Qty Part Number Description Batch	40181  

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/07/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:39 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 40496

Part Number: D3183045

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

7/08/08/28 46

7.0 QC5 INSPECT WORK TO CURRENT STEP



counts

8/08/08/28 46

Comment: INSPECT WORK TO CURRENT STEP

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Emile

7/08/08/28 46

9.0 QC21 FINAL INSPECTION/W/O RELEASE



46

*15/08/08/28
MF 08-07-28*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40494
Description: Cap	Part Number:	D3183-9
Inspection Dwg: D3183	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: J.F.	Audited by: M.	Prototype Approval:	N/A
Date: 08/07/26	Date: 08/07/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3183-045)	KJ/RF	
B	06.03.09	Dimension Ø0.830 was Ø0.850	KJ/JLM	

DARTCOPY IS
MADE
FOR
DART

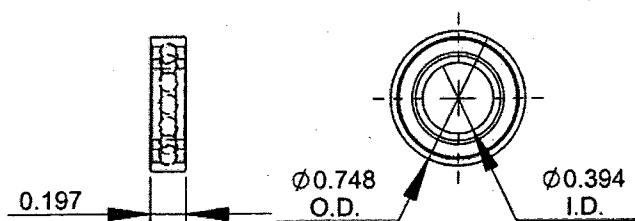
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CHECKED	APPROVED	DRAWING NO.	REV. C
		D3183	SHEET 1 OF 4
DATE	04.02.17	TITLE	SCALE
		BRACKET ASSEMBLY	
			1:1

RELEASED
04.03.01D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)

A	03.01.24	NEW ISSUE
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431
C1	04.11.09	0.830 WAS 0.850

D3121-21 BOLT (1)
D3183-045 BEARING ASSEMBLY (1)D3183-1 BRACKET FOR -041 (SHOWN)
OR
D3183-2 BRACKET FOR -042 (OPPOSITE)
OR
D3183-3 BRACKET FOR -043 (SIMILAR)
OR
D3183-4 BRACKET FOR -044 (SIMILAR)

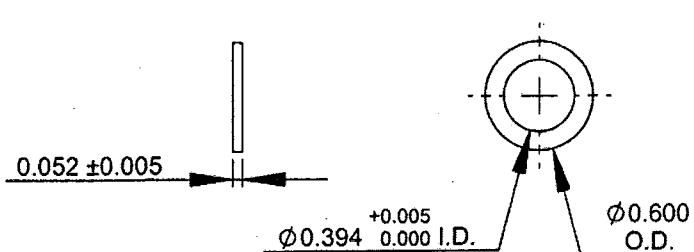
D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING: SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6809ZZP COPY
- 3) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
40496



D3183-7 WASHER

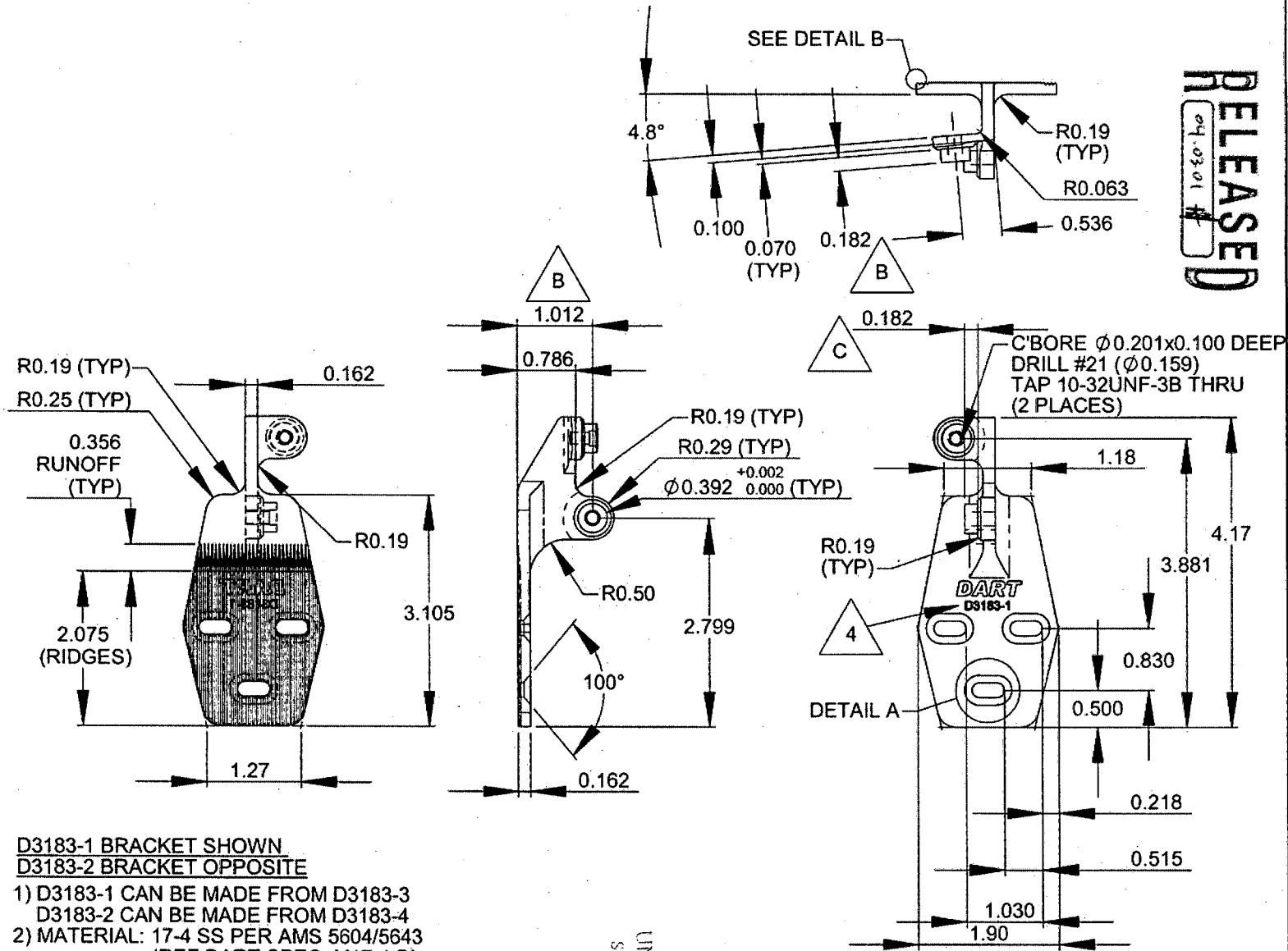
- 1) MATERIAL: AISI 303 ROUND BAR (M303R)
ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40446

SHOP UOFI
RETURN TO

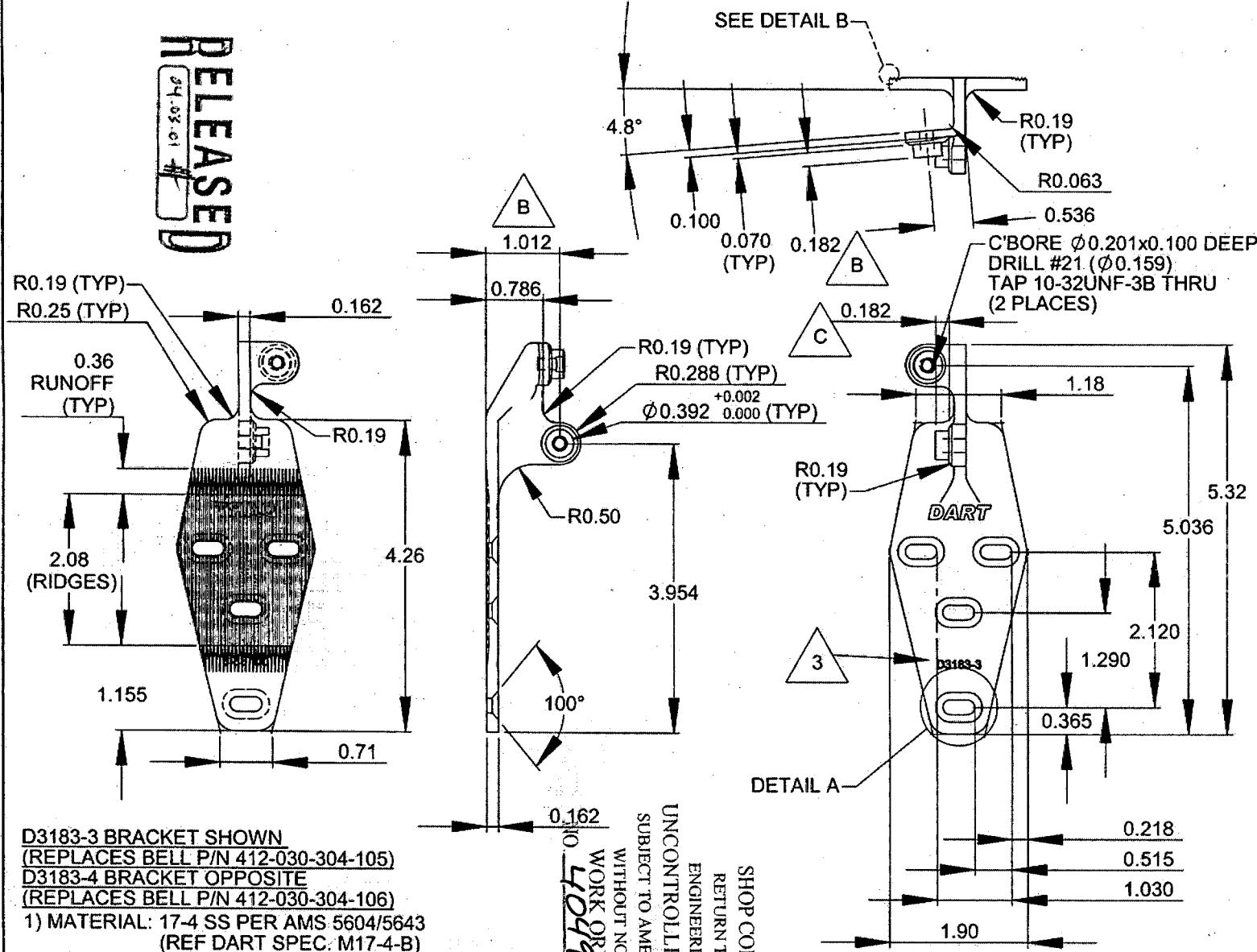
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DESIGN	DRAWN BY	SHEET 2 OF 4		
CHECKED	APPROVED	DRAWING NO.	REV C	SCALE
DATE	TITLE	D3183	1:2	
04.02.17	BRACKET ASSEMBLY			

DART

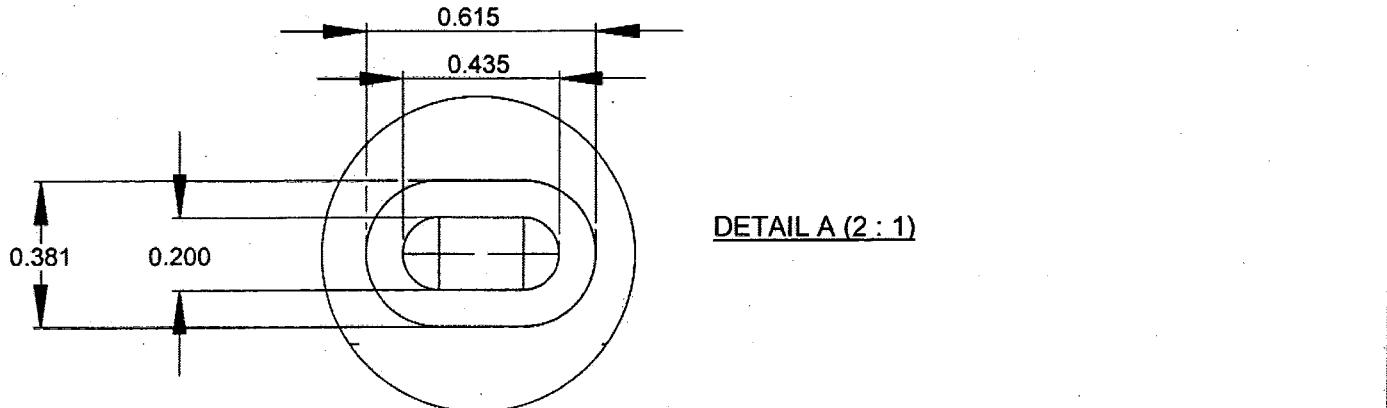
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DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
		DRAWING NO.
		D3183
DATE	TITLE	REV. C
04.02.17	BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE
		1:2



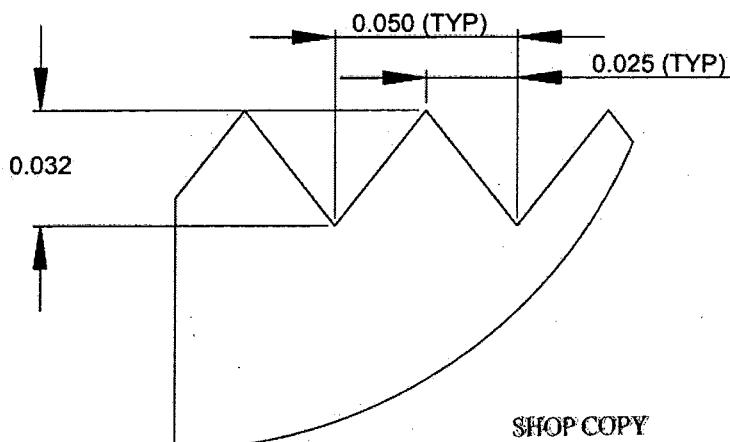


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE	04.02.17	D3183	SHEET 4 OF 4



RELEASED
04.03.01

DETAIL B (20 : 1)



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RETURN TO

ENGINEERING

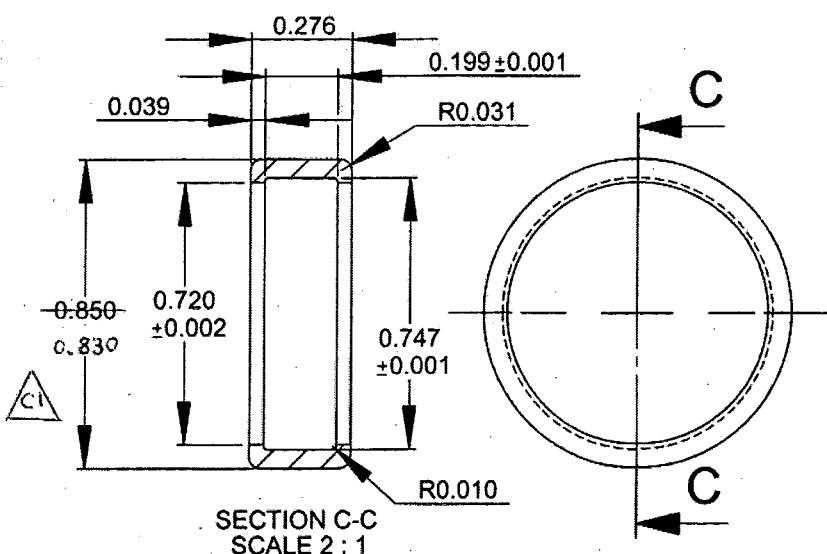
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WITHOUT NOTICE

WORK ORDER

NO. 40496



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00 (REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND D3183-9 CAP

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